

Work Order ID

Wednesday, April 11,

Work Order ID 82954

Wednesday, April 11, 2012 3:04:27 PM

Item ID: D35

Revision ID:

Item Name: Skid

Start Date: 4/1

Required Date: 4/26

Reference:

Approvals: Pro

QC

Sequence ID/
Work Center ID

110

110

Skidtubes

Skidtubes

Item ID: D350-636-011

Accept

N900040100

Setup Start

NS1

Stop

NS2

Revision ID:

Item Name: Skidtube LH

Start Date: 4/11/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/26/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

P

Date: 1204-11

Tooling:

Date:

NR1

QC:

Date:

SPC (Y/N):

Date:

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

ToolID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D2750	F
D3492	C

100

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy blue file and type labels per PPP D350-636-011 CHG 006

SCRAP

Dart Aerospace

Dart Aerospace Ltd

W/O:

W/O: 82954

WORK ORDER CHANGES

DATE	STEP

Part No:

Part No: D3D-636-01 PAR #: Fault Category: Landig gear / Skip turn NCR: Yes No DQA: Date: 12/04/19

R

Resolution: scrap

Disposition: scrap

QA: N/C Closed: CK Date: 12/4/19

NCR:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12.04.19	110	Aft holes not aligning with saddles P.C.	WDS 12/04/19 Q51042	Scrap. Not aligning even after opening aft hole. QP 12.04.19	12-4-19	12-4-19	12/04/19 Q51042	S 12/04/19

NOTE: Date & initia

NOTE: Date & initial all entries

H:\VFORMS\Quality Ass

H:\VFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 82954

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Page 3

Wednesday, April 11, 2012 3:04:27 PM

Item ID: D350-636-011

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Skidtube LH

Stop

NS2

Start Date: 4/11/2012 Start Qty: 1.00

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Required Date: 4/26/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

11-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left
from bending as per QSI 004
A/R Aluminum Rod batch: _____

12-Grind welds flush as per Dwg D2750

120

QC10- Inspect visual per QSI004- ground welds

0.00

120

QC

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 82954

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Start Date: 4/11/2012 Start Qty: 1.00

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2**Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Hand Finishing

150

QC7-Inspect Chemical Conversion Coat

0.00

150

QC

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 82954***82954***

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Item Name: Skidtube LH

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Required Date: 4/26/2012 Req'd Qty: 1.00

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Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
11-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750									
170 *170* QC Quality Control	12-Deburr holes QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00							
QC5- Inspect part completeness to step on W/O									
180 *180* QC Quality Control		0.00 0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item Name: Skidtube LH

Start Date: 4/11/2012 **Start Qty:** 1.00

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Required Date: 4/26/2012 **Req'd Qty:** 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

190

Pressure Wash per QSI005 4.3

0.00

190

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

200

Powdercoat

Memo

0.00

Powder Coating

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

210

QC3- Inspect Part Finish

0.00

210

QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

W/O:		WORK ORDER CHANGES					
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Work Order ID 82954

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Wednesday, April 11, 2012 3:04:28 PM

Item ID: D350-636-011

Accepted

N900040100

Setup S

start *NS1*

Revision ID:

Item Name: Skidtube LH

Start Date: 4/11/2012 **Start Qty:** 1.00

1

Cust Item ID:

Required Date: 4/26/2012 **Req'd Qty:** 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date: _____

SPC (Y/N)

Date:

Stop

NR 1

W/O:		WORK ORDER CHANGES							
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D350-636-011

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N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Skidtube LH

Start Date: 4/11/2012 **Start Qty:** 1.00

1

Cust Item ID:

Required Date: 4/26/2012 **Req'd Qty:** 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

270

270

Packaging

Packaging

0.00

Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-011

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

0.00

Quality Control

4/12/2014-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 1

Wednesday, April 11, 2012 3:04:32 PM

Work Order ID: 82954

82954

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 4/11/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I 02.09.25 Rearranged procedure steps KJ

IPP Rev:J 06-03-23 As per Rev D JLM

IPP Rev:K 06-07.13 As per dsi9343 EC

IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC

IPP Rev:M 08-04-22 update steps 4, 13 DD verified by:EC

IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec

IPP Rev:O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010

DD verf:EC IPP Rev:P 10.06.22 revise

seq110 DD verf:EC

IPP Rev:Q 10.10.01 as per IIN revH

DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3492-1		Manufactured	No			230	Each	30.0000	8	8		**	

D3492-1

Plug

Location Loc Qty Loc Code

FP002 30

69531 8

74444 2

76235 4

77037 16

D3492-3

Manufactured

No

230

Each

69.0000

8

**

D3492-3

Plug

Location Loc Qty Loc Code

FP-A 69

81967 69

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 82954

82954
D350-636-011

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 4/11/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

259.0000

8

8

*********NAS1611-010***

O-RJNG

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	50	
110915	0	
120770	50	
FP001	209	
110915	14	
117460	8	
118077	1	
118612	3	
119438	47	
120986	50	
121166	36	
121259	50	

NAS1149D0863J

Purchased

No

250

Each

211.0000

2

*********NAS1149D0863.J***

WASHER

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST298	211	
118078	36	
119307	75	
120308	100	

D2744

Manufactured

No

110

Each

39.0000

1

1

*********D2744***

Cap

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG002	39	
62715	1	
70881	3	
78900	35	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Wednesday, April 11, 2012 3:04:32 PM

Work Order ID: 82954

82954

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 4/11/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

D2600-3-BENT

Manufactured No

110

Each

24.0000

1

1

**

B 83305

MT 12-04-18

D2600-3-BENT

Extrusion Bent

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	24	
66875	7	
73253	1	
75021	1	
75022	1	
75023	1	
81330	4	
82347	9	

D2743

Manufactured No

160

Each

290.0000

8

8

**

D2743

Crossbolt Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	-3	
81965	207	
LG001	293	
67766	4	
68251	3	
73403	64	
74445	1	
78603	2	
79517	9	

D2739

Manufactured No

160

Each

5.0000

1

1

**

D2739

350 I Beam

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	5	
72155	1	
81508	1	
82123	3	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Wednesday, April 11, 2012 3:04:32 PM

Work Order ID: 82954***82954*****Parent Item:** D350-636-011***D350-636-011*****Parent Item Name:** Skidtube LH**Start Date:** 4/11/2012**Required Date:** 4/26/2012**Start Qty:** 1.00**Required Qty:** 1.00

D3490-3

Manufactured No

160

Each

58.0000

4

4

*********D3490-3***

Cross Bolt Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	56	
82016	56	
LG001	2	
78800	2	

D3490-1

Manufactured No

160

Each

92.0000

4

4

*********D3490-1***

Cross Bolt Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	83	
81976	83	
LG001	9	
62450	2	
74875	4	
77042	3	

ALS4-1032-225

Purchased No

220

Each

2,433.000

38

38

*********AI S4-1032-225***

Insert

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST281	2410	
108696	146	
110768	62	
118386	55	
118966	68	
120671	79	
121269	2000	
ST282	23	
120410	10	
120451	13	

W/O:		WORK ORDER CHANGES							
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82954
D350-636-011

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 4/11/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

D3793-3

Manufactured No

230

Each

30.0000

1

1

*********D3793-3***

Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	23	
80434	11	
82166	12	
FP002	7	
78935	7	

AN8C35A

Purchased No

230

Each

104.0000

1

1

*********AN8C35A***

BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	103	
115960	1	
117834	7	
118286	45	
121275	50	
ST346	1	
114442	0	
115188	0	
115960	1	

D3793-1

Manufactured No

230

Each

26.0000

1

1

*********D3793-1***

Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	26	
78901	10	
82171	16	

W/O:		WORK ORDER CHANGES							
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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D350-636-011

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 4/11/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

D3488-041

Manufactured No

230

Each

10.0000

1

1

*********D3488-041***

Blade Fitting Assembly, LH

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	10	
61689	1	
75056	1	
77021	8	

D3794-3

Manufactured No

230

Each

23.0000

1

1

*********D3794-3***

Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	23	
74530	2	
80436	21	

AN6C44A

Purchased No

230

Each

170.0000

4

4

*********AN6C44A***

BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	2	
103964	2	
ST343	168	
120143	25	
120465	23	
121013	20	
121167	100	

W/O:		WORK ORDER CHANGES							
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 7

Wednesday, April 11, 2012 3:04:33 PM

Work Order ID: 82954***82954***
D350-636-011**Parent Item:** D350-636-011**Parent Item Name:** Skidtube LH**Start Date:** 4/11/2012**Required Date:** 4/26/2012**Start Qty:** 1.00**Required Qty:** 1.00

MS21083C8

Purchased

No

230

Each

105.0000

1

1

*********MS21083C8***

NUT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
304	50	
121185	50	
FP002	1	
115884	1	
ST303	5	
115884	0	
118077	1	
119309	2	
119638	2	
ST304	49	
120142	7	
120731	17	
121011	25	

D3536-25

Manufactured

No

230

Each

22.0000

1

1

*********D3536-25***

Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	14	
81342	14	
FP002	8	
78902	8	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 8

Wednesday, April 11, 2012 3:04:33 PM

Work Order ID: 82954

82954
D350-636-011

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 4/11/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

D3631-I

Manufactured No

230

Each

227.0000

8

8

*********D3631-1***

Washer

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	FG	100	
	81874	100	
	ST072	127	
	68062	2	
	75548	125	

D3791-I

Manufactured No

230

Each

25.0000

1

1

*********D3791-1***

Wearplate

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	FP002	25	
	62239	2	
	78897	7	
	82168	16	

AN960C10L

NAS1149C0332 R Purchased

No

230

Each

0.0000

38

38

*********AN960C10I ***

washer

D2745

Manufactured No

230

Each

48.0000

8

8

*********D2745***

Bushing

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	FP	46	
	79518	46	
	FP001	2	
	69529	1	
	76142	1	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 9

Wednesday, April 11, 2012 3:04:33 PM

Work Order ID: 82954

82954
D350-636-011

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 4/11/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

230

Each

1,592.000

34

34

*********AN3C5A***

Bolt

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	FP001	7	
	115835	7	
	ST350	1585	
	116419	28	
	117343	13	
	117764	7	
	117872	2	
	119749	23	
	120423	512	
	1210168	500	
	121255	500	

D3537-1

Manufactured

No

230

Each

69.0000

3

*********D3537-1***

Wearpad

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	FG	10	
	79833	10	
	FP002	59	
	69817	5	
	80337	5	
	81361	49	

NAS1149C0832R

Purchased

No

230

Each

293.0000

1

*********NAS1149C0832R***

WASHER

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	ST297	293	
	114915	293	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 10

Wednesday, April 11, 2012 3:04:33 PM

Work Order ID: 82954

82954
D350-636-011

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 4/11/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

501.0000

4

4

*********AN3C6A***

BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	1	
111982	1	
ST351	500	
111982	2	
116419	23	
116549	2	
116704	12	
117619	10	
117688	1	
117872	5	
118422	13	
119449	21	
120423	11	
120693	400	

NAS1611-013

Purchased

No

230

Each

218.0000

8

8

*********NAS1611-013***

O-RING

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	218	
116582	5	
117291	2	
117887	53	
119623	36	
120910	4	
121166	68	
121259	50	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 11

Wednesday, April 11, 2012 3:04:33 PM

Work Order ID: 82954

82954
D350-636-011

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 4/11/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured

No

230

Each

39.0000

1

1

*********D3535-25***

Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	39	
62233	1	
80331	10	
81357	11	
82156	17	

D3794-1

Manufactured

No

230

Each

39.0000

1

1

*********D3794-1***

Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	23	
82167	23	
FP002	16	
75042	4	
80435	12	

MS21043-6

Purchased

No

230

Each

765.0000

4

4

*********MS21043-6***

NUT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	20	
103693	20	
ST301	745	
112314	39	
117887	6	
118384	200	
120308	500	

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Shop Packet Print

Page 11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 12

Wednesday, April 11, 2012 3:04:33 PM

Work Order ID: 82954

82954
D350-636-011

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 4/11/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

D3493-1

Manufactured No

250

Each

87.0000

2

2

*********D3493-1***

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST050	87	_____
70697	2	_____
77573	4	_____
78835	40	_____
82023	41	_____

MS21083C8

Purchased No

250

Each

105.0000

2

2

*********MS21083C8***

NUT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
304	50	_____
121185	50	_____
FP002	1	_____
115884	1	_____
ST303	5	_____
115884	0	_____
118077	1	_____
119309	2	_____
119638	2	_____
ST304	49	_____
120142	7	_____
120731	17	_____
121011	25	_____

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 13

Wednesday, April 11, 2012 3:04:33 PM

Work Order ID: 82954***82954***
D350-636-011**Parent Item:** D350-636-011**Parent Item Name:** Skidtube LH**Start Date:** 4/11/2012**Required Date:** 4/26/2012**Start Qty:** 1.00**Required Qty:** 1.00

AN8C21A

Purchased

No

250

Each

121.0000

2

2

*********AN8C21A***

BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST343	121	_____
118758	5	_____
120094	26	_____
121067	20	_____
121167	20	_____
121275	50	_____

NAS1515H3L

Purchased

No

230

Each

190.0000

4

4

*********NAS1515H3L ***

WASHER

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	40	_____
102472	40	_____
ST277	150	_____
118686	3	_____
119438	1	_____
120360	96	_____
121243	50	_____

D2741

Manufactured

No

250

Each

61.0000

1

1

*********D2741***

Blade, 350 Skidtube

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST	-10	_____
ST466	71	_____
71856	1	_____
76984	20	_____
79516	40	_____

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Wednesday, April 11, 2012 3:04:33 PM

Work Order ID: 82954

82954
D350-636-011

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 4/11/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

D3532-1

Manufactured No

250

Each

51.0000

2

2

*********D3532-1***

Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST053	51	
78839	27	
82041	24	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMNT, LH
	1			D2750-2	SKIDTUBE WELDMNT, RH
	1			D2750-3	SKIDTUBE WELDMNT, LH
		1		D2750-4	SKIDTUBE WELDMNT, RH
1	1			D3488-041	BLADE FITTING, LH
	1			D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
8	8	8	8	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8	8	8	D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 82954*PL12-04-11***RELEASED**
6/27/22 M

F	INCORPORATE DS1 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3631-1 (ZN C8-1) WEARSHOE HOLES UNDER FWD/FT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (3) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/8157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PL</i>	DART AEROSPACE USA, INC.	
DRAWN	<i>PL</i>	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.	<i>PL</i>	D2750	SHEET 1 OF 11
APPROVED	<i>PL</i>	TITLE	SCALE
DE APPR.	<i>PL</i>	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE USA, INC. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

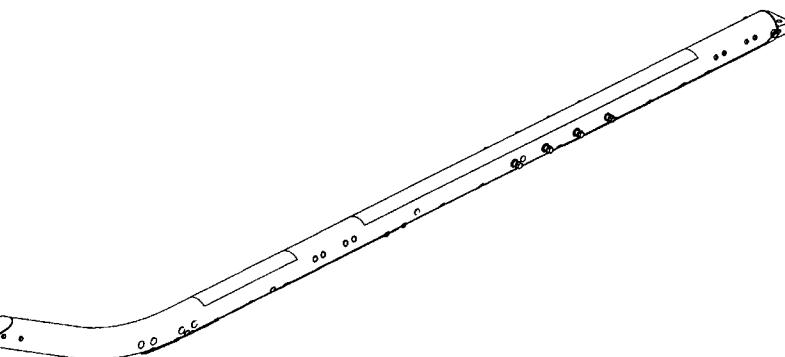
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

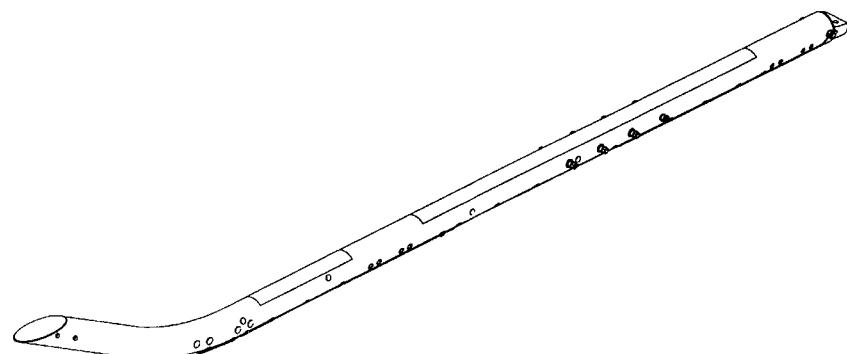
8 7 6 5 4 3 2 1

D

D



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED
08.07.16

DESIGN	P01	DART AEROSPACE USA, INC.
DRAWN	A1	PORT HADLOCK, WA
CHECKED	B1	DRAWING NO. REV. F
MFG. APPR.	N/A	D2750 SHEET 2 OF 11
APPROVED	N/A	TITLE SCALE
DE APPR.	N/A	350 SKIDTUBE ASSEMBLY NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

8 7 6 5 4 3 2 1

A

A

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

D

D

C

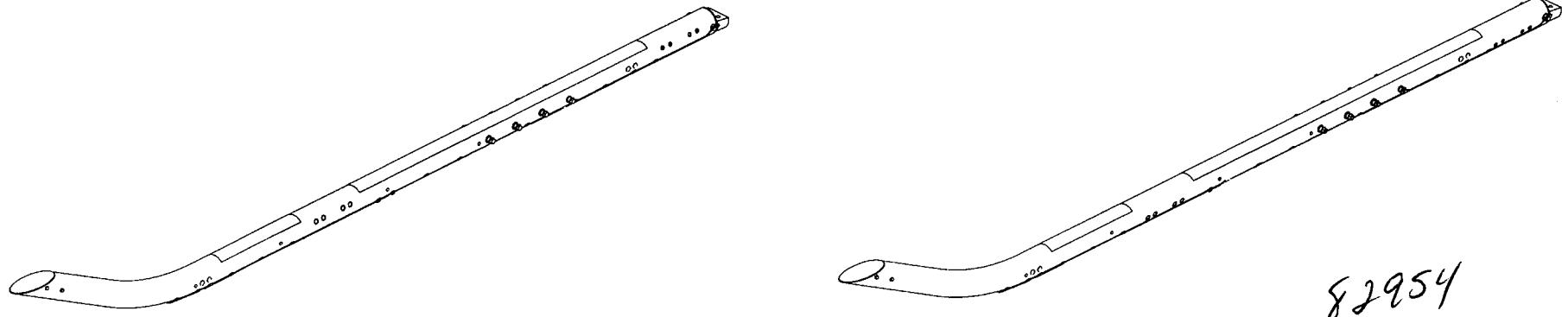
C

B

B

A

A



D2750-043 350 SKIDTUBE ASSEMBLY, LH

D2750-044 350 SKIDTUBE ASSEMBLY, RH

RELEASED
(64-9-221M)

DESIGN	<i>RD</i>	DART AEROSPACE USA, INC.	
DRAWN	<i>PJ</i>	POR	PORT HADLOCK, WA
CHECKED	<i>AS</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>NA</i>	D2750	SHEET 3 OF 11
APPROVED	<i>MM</i>	TITLE	SCALE
DE APPR.	<i>MM</i>	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OTHER PURPOSE THAN THAT FOR WHICH IT WAS PROVIDED BY DART AEROSPACE USA, INC. WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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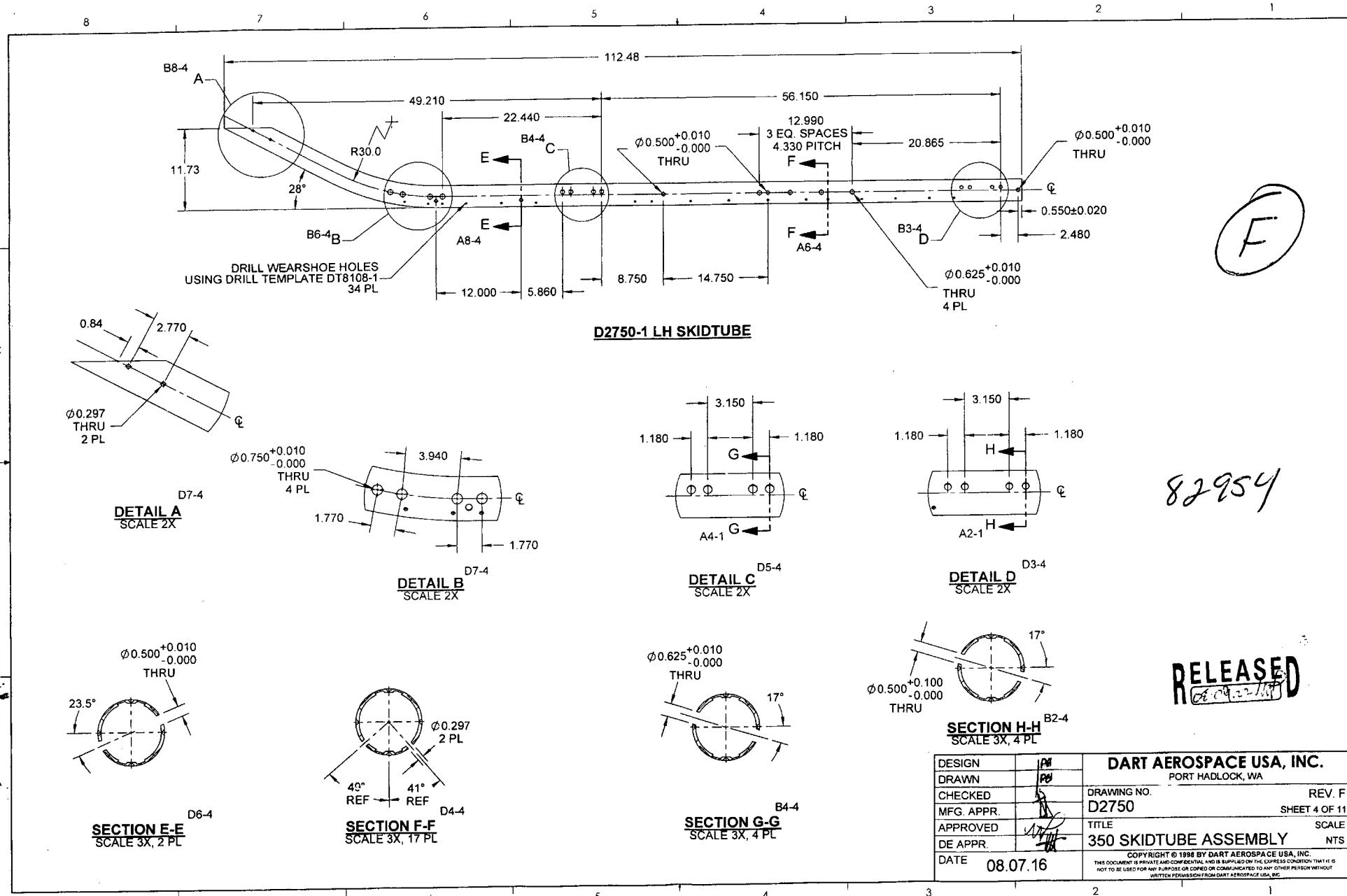
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DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	PB	DART AEROSPACE USA, INC.
DRAWN	PB	PORT HADLOCK, WA
CHECKED		REV. F
MFG. APPR.		DRAWING NO. D2750
APPROVED	VJH	SHEET 4 OF 11
DE APPR.	VJH	TITLE 350 SKIDTUBE ASSEMBLY
DATE	08.07.16	SCALE NTS

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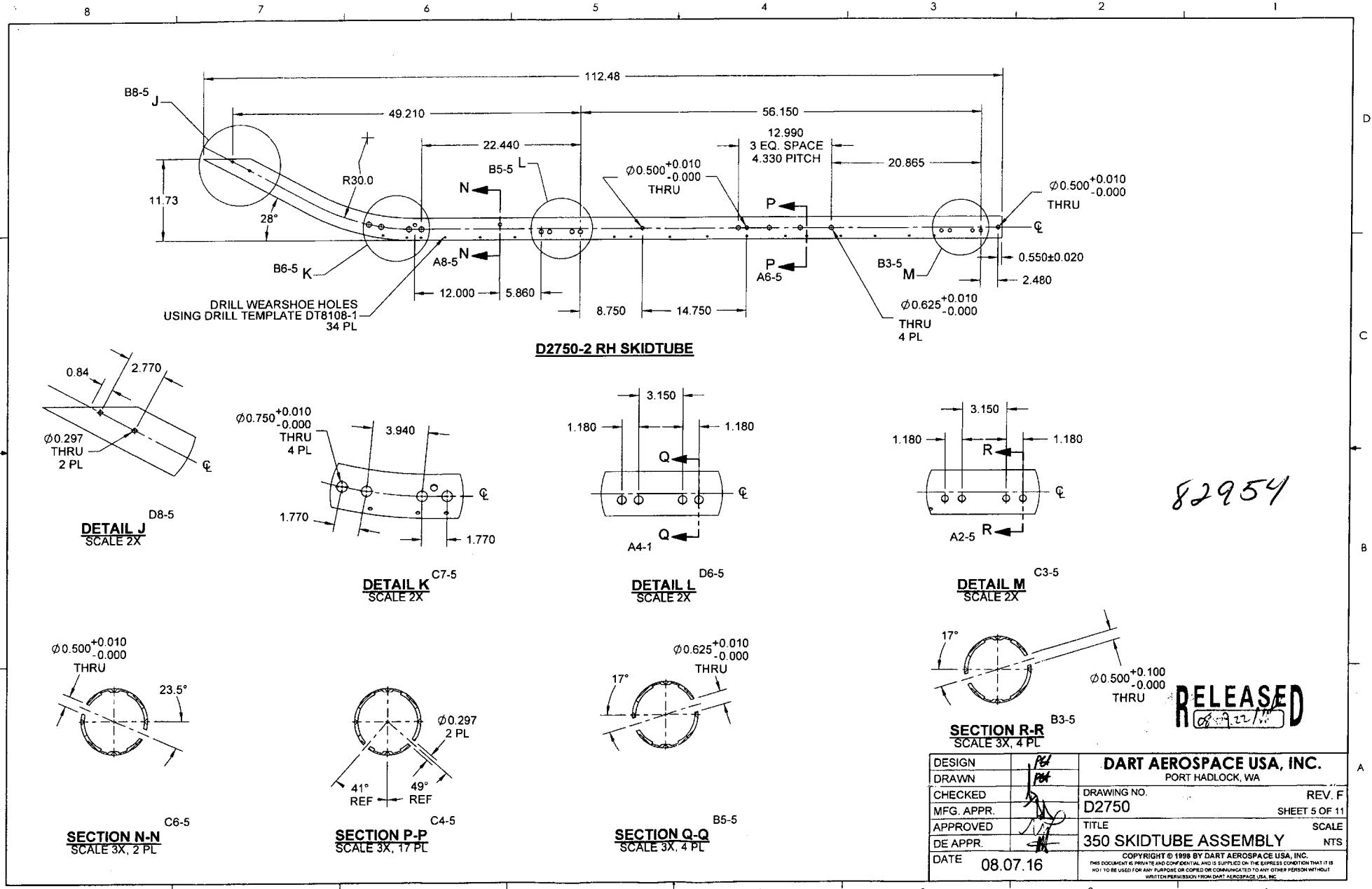
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NOTE: Date & initial all entries



82954

RELEASED
08-22-17

DESIGN	<i>P&I</i>	DART AEROSPACE USA, INC.	
DRAWN	<i>P&I</i>	PORT HADLOCK, WA	
CHECKED	<i>S</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>S</i>	D2750	SHEET 5 OF 11
APPROVED	<i>S</i>	TITLE	
DE APPR.	<i>S</i>	350 SKIDTUBE ASSEMBLY NTS	
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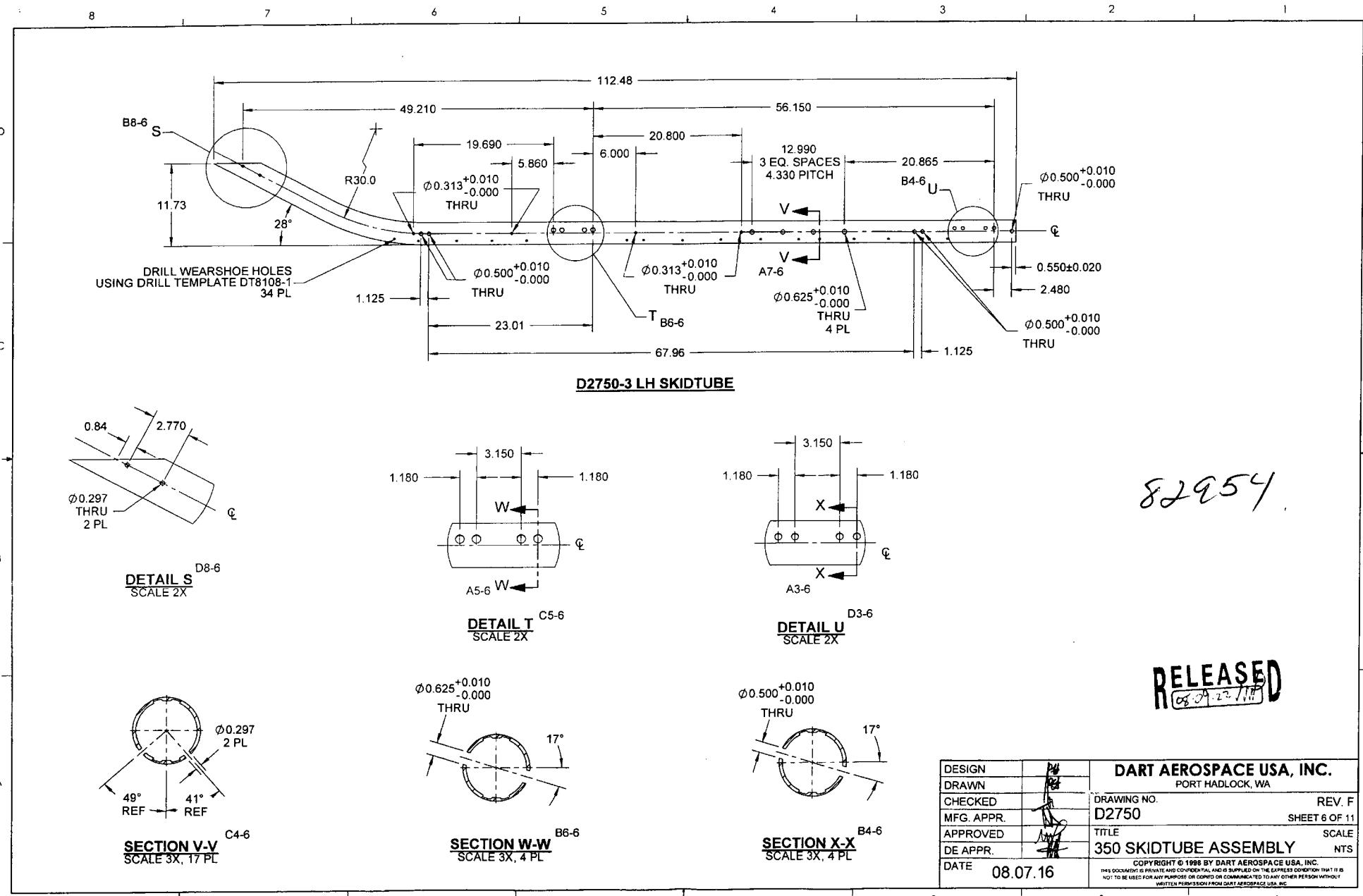
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82954

RELEASED
05-09-2018

DESIGN	<i>PS</i>	DART AEROSPACE USA, INC.	
DRAWN	<i>PS</i>	PORT HADLOCK, WA	
CHECKED	<i>A</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>PS</i>		SD2750
APPROVED	<i>MM</i>	TITLE	SCALE
DE APPR.	<i>MM</i>		350 SKIDTUBE ASSEMBLY
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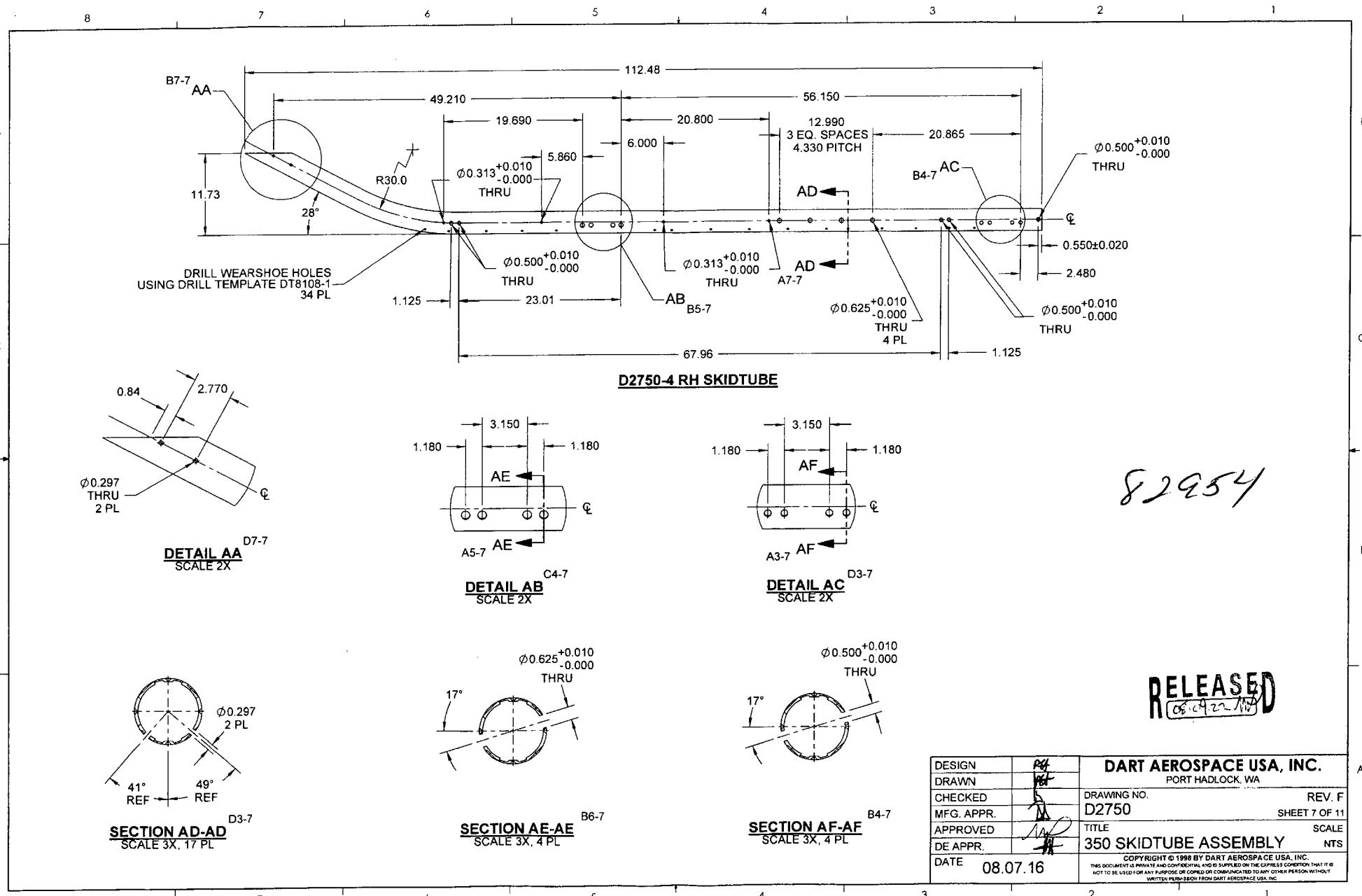
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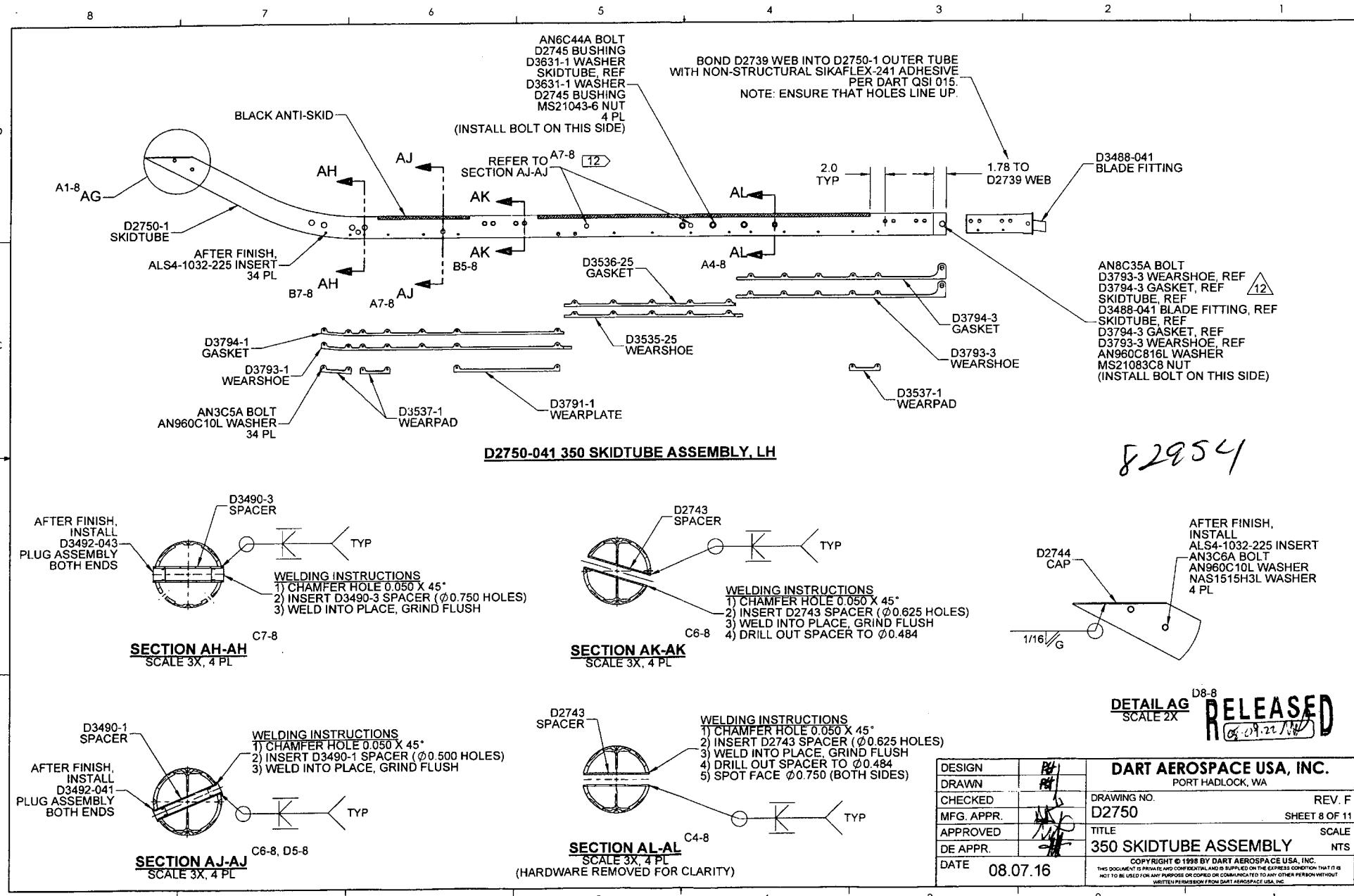
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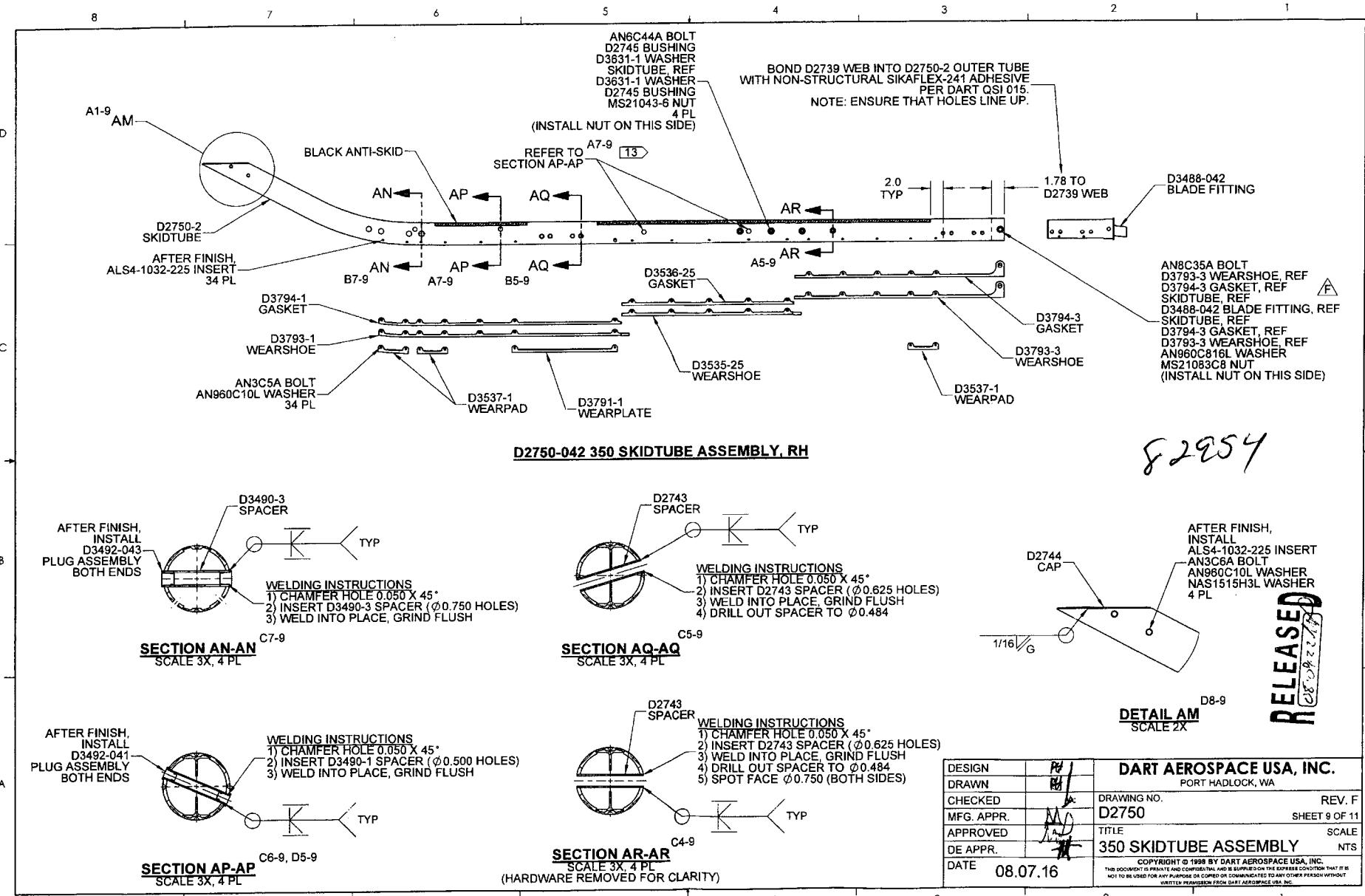
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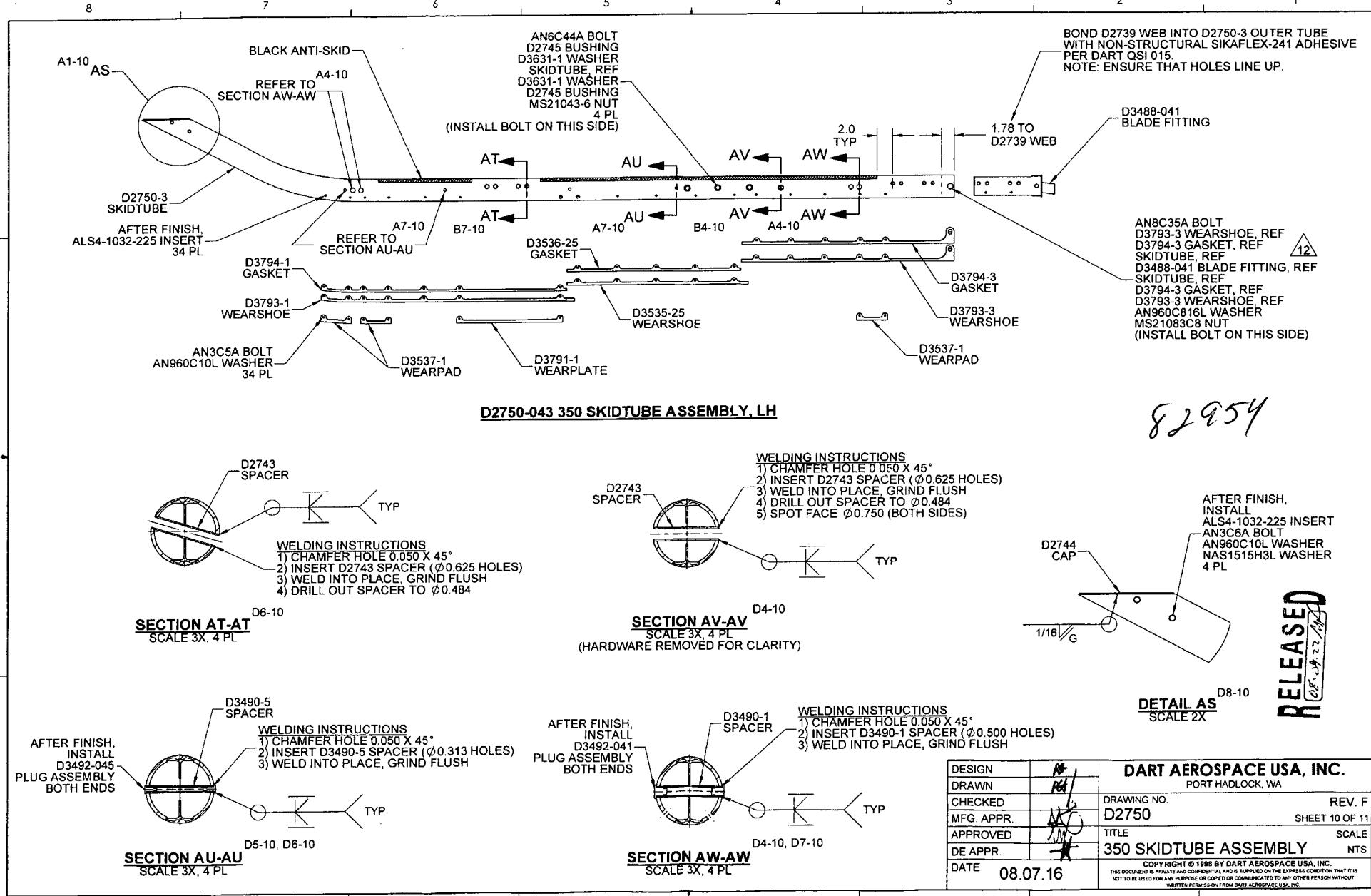
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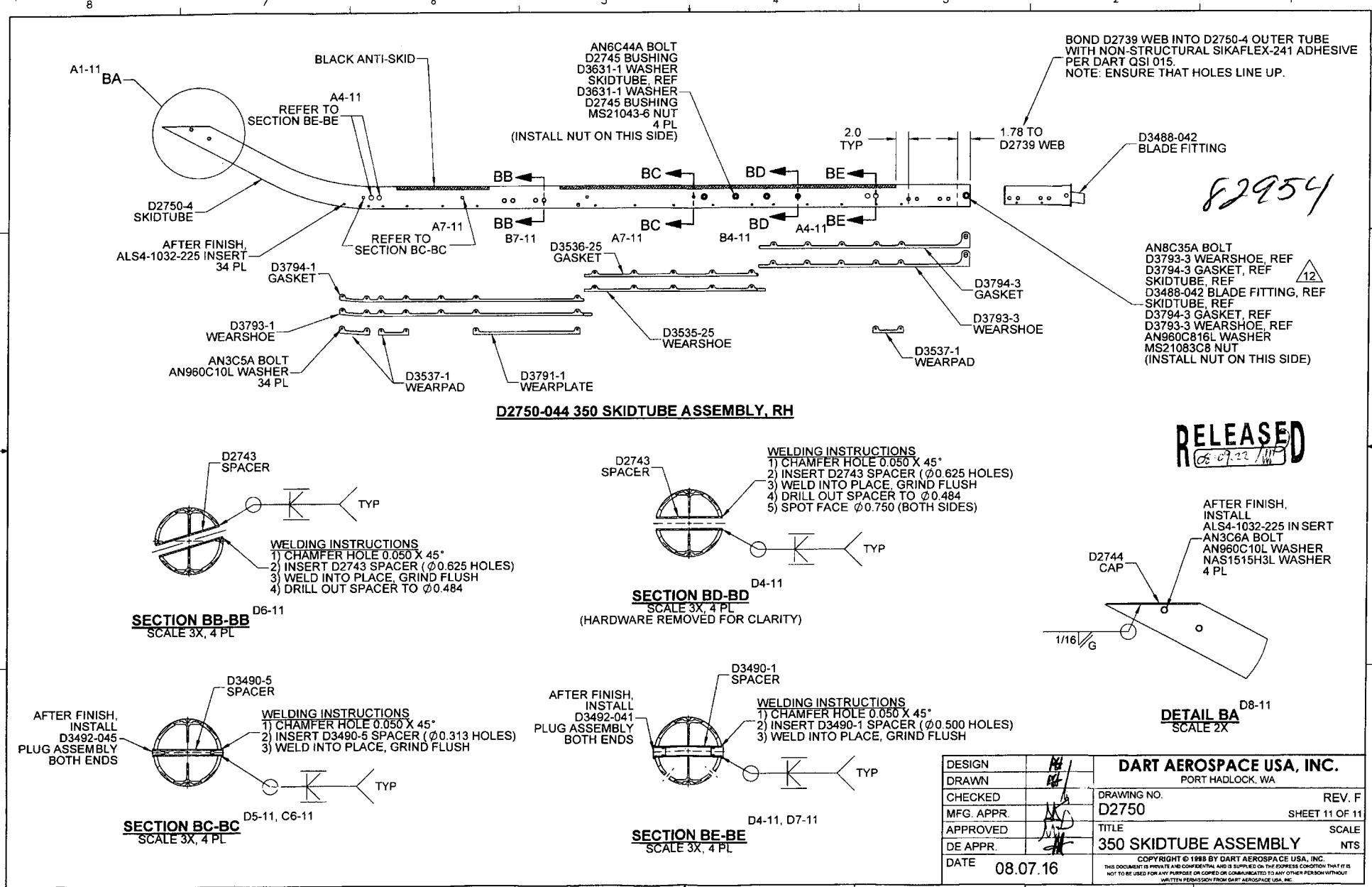
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